

Date: Tuesday, 03/03/2009 1:02:51 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 46243
Estimate Number : 10804
P.O. Number :
This Issue : 03/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : SMALL /MED FAB
Previous Run : 46236
Written By :
Checked & Approved By :
Comment :

Drawing Name : SIDE
Part Number : D412785004401F
Drawing Number : D412-785-004-401
Project Number :
Drawing Revision :
Material :
Due Date : 10/03/2009 Qty: 7 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



PRELIM



Comment: FLOW WATER JET

9-3-12
ml 09 04 02 (2)

(2)

(3)

9-3-12

(5)

CUT PER DRWG D412-785-004-401 REV.A

2.0 M6061T6S040 6061-T6 .040 Sheet



1111224

105842

ml 09 04 02 (2)



(P)

Comment: Qty.: 2.8100 sf(s)/Unit Total: 19.6700 sf(s)
6061-T6 Sheet 0.032"

1040

ml 09 03 11 (2)

(2)

+3

(5)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 04 02 (2)

ml (For HB)

09 03 11 (2)



(5)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

+3

4.0 QC8 SECOND CHECK



09 03 11 5



Comment: SECOND CHECK

Scrubbing (x2)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



09-04-2



(x5)

Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI005

MD/AR

09/03/12

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



09 03 12



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(5)



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Drawing Name: SIDE

Job Number: 46243

Part Number: D412785004401F

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ID AND STK

PUT ASIDE TO SEND TO EAGLE

09.03.12 (5)

pb 8126

8/09/04/03 (x2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/03

Job Completion



02/09/04/03

u 09.03.12

DART AEROSPACE LTD		Work Order: 46243
Description: SIDE	Part Number: D412-785-064-401	
Inspection Dwg: D412-785-064-401	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

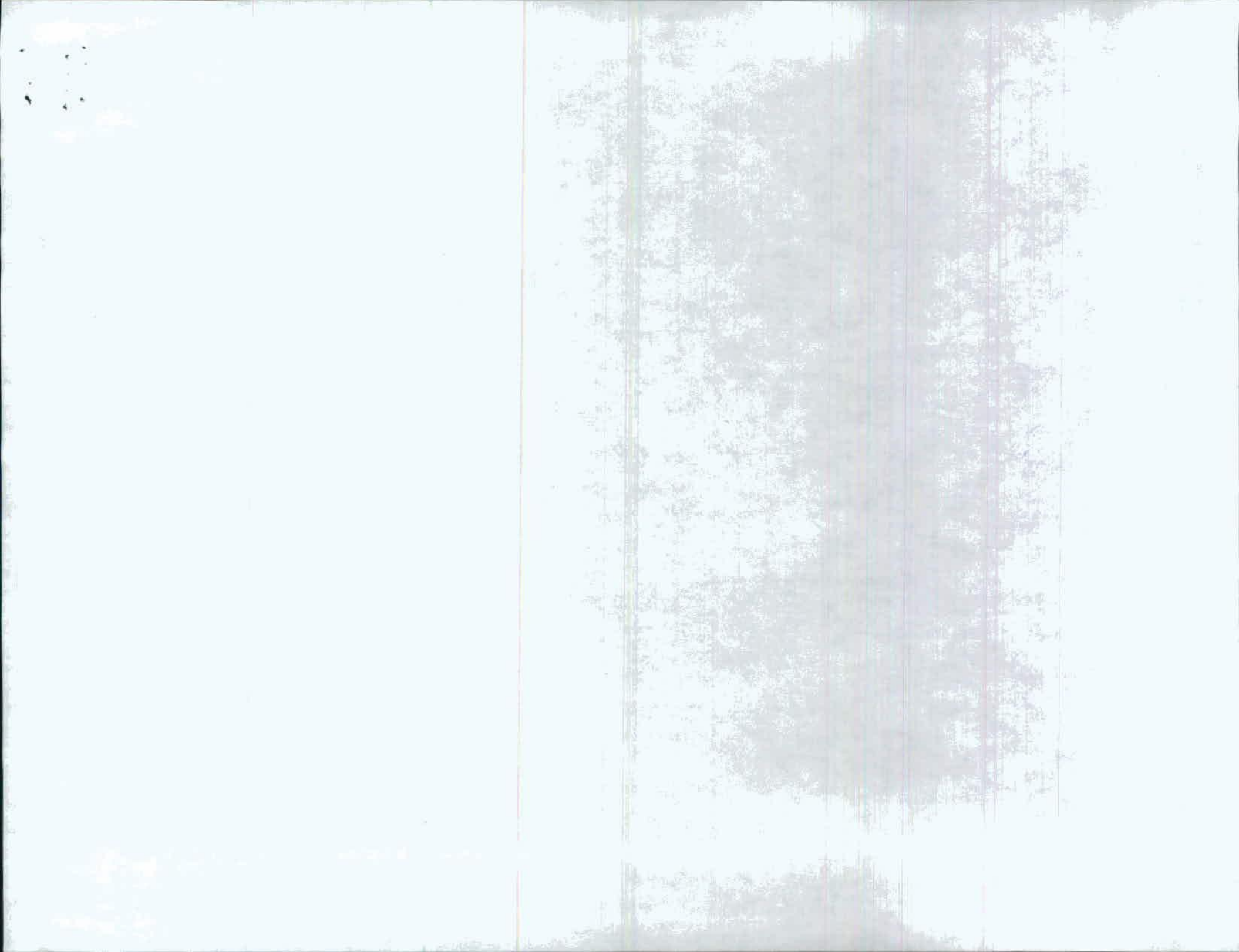
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓			
.14	+/- .030	.140	✓			
.66	+/- .030	.662	✓			
3.84	+/- .030	3.833	✓			
.23	+/- .036	.233	✓			
15.23	+/- .030	15.23	✓			
23.13	+/- .030	23.13	✓			
34.53	+/- .030	34.53	✓			
.39	+/- .030	.386	✓			
2.60	+/- .030	2.597	✓			
1.300	+/- .010	1.298	✓			
1.15	+/- .030	1.141	✓			
10.00	+/- .030	10.001	✓			
1.000	+/- .010	1.001	✓			
7.00	+/- .030	6.991	✓			
1.000	+/- .010	.998	✓			
3.45	+/- .030	BEND				
.90	+/- .030	.904	✓			
39.10	+/- .030	39.10	✓			
10.32	+/- .030	10.325	✓			
Ø 1.038	+/- .010	1.038	✓			

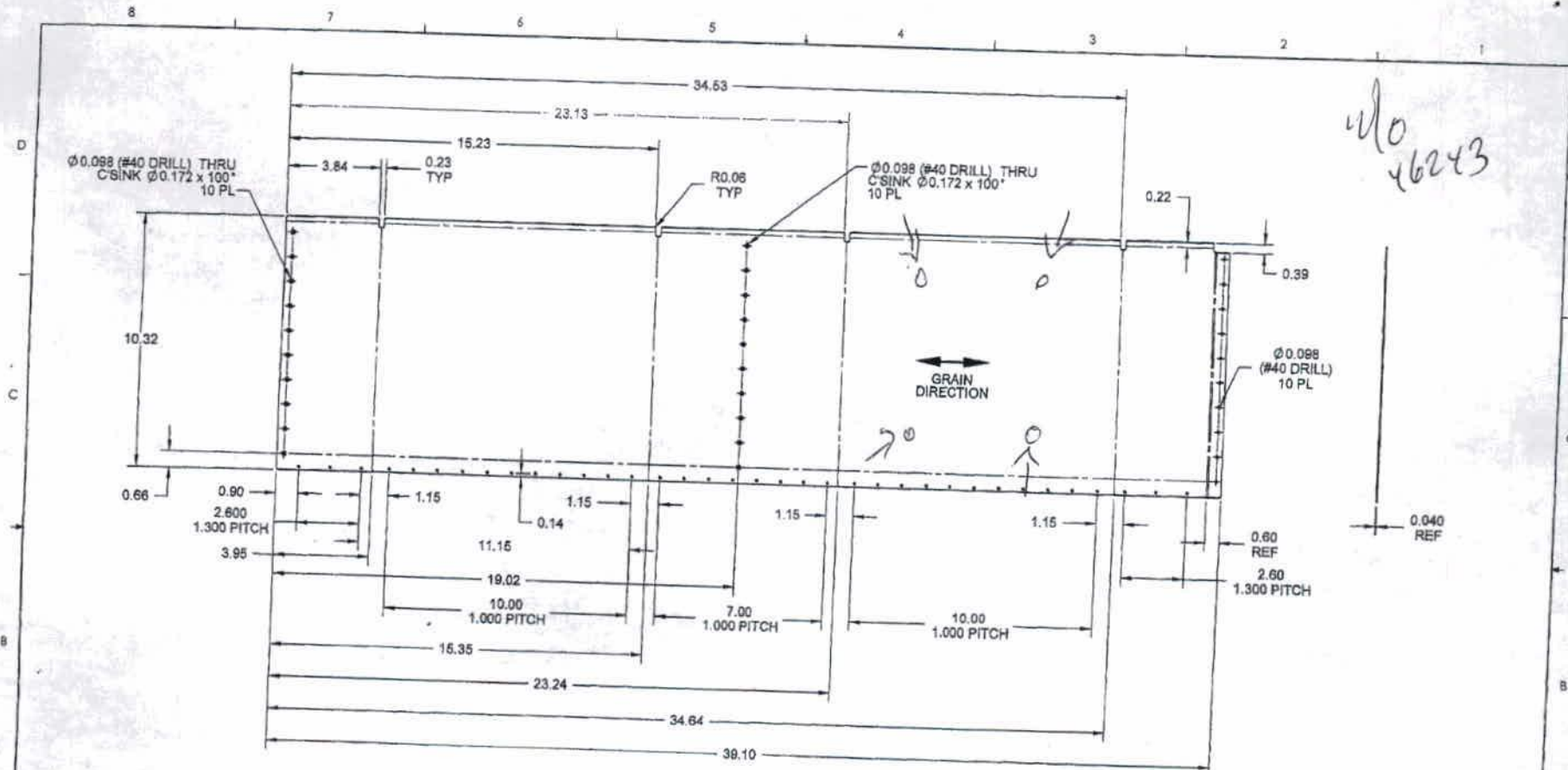
Measured by: 18
Date: 9-2-12

Audited by: [Signature]
Date: 9-3-11

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





D412-785-004-401F FLAT PATTERN

NOTES:

- 1) MATERIAL: 8061-T6 ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/11 OR AMS4025 OR AMS 4027
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.57 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE CALGARY, ALBERTA, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D412-785-004-401	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	SIDE	NTS
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